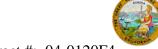
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 70.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-005092 Address: 333 Burma Road **Date Inspected:** 15-Dec-2008

City: Oakland, CA 94607

Project Name: SAS Superstructure **OSM Arrival Time:** 830 **OSM Departure Time:** 1800 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Japan Steel Works **Location:** Muroran, Japan

CWI Name: CWI Present: Yes Chung Kuan No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No **Weld Procedures Followed:** Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes N/A **Approved Drawings:** Yes No **Approved WPS:** No Yes No N/A **Delayed / Cancelled:**

34-0006 **Bridge No: Component:** Tower Jacking and Deviation Saddles

Summary of Items Observed:

Caltrans Quality Assurance Inspector (QAI) representative Mr. Wai Pau traveled to Japan Steel Works (JSW) Muroran plant to observe two welders perform Flux Cored Arc Welding (FCAW) processes on the two ribs 9-10 and 9-11 of T1-3 tower saddle steel structure. The two weld numbers 9Y-10V-3-2 and 9Y-11V-3-3. The material used was reported by CWI Mr. Chung Kuan as ASTM 709-Gr345 plate having a thickness measurement of 120mm. The weld joint design used butt joint, double-V groove partial joint penetration groove weld (PJP). The filler metal and shield gas used for FCAW welding is Hoballoy wire TM-95K2, 1.6 diameter with 100% C02 made by Hobart Brothers, USA. The parameters used for FCAW welding of assemblies were conducted in accordance with Caltrans approved WPS #SJ-3012-3. The FCAW welding process and parameters have been monitored and recorded by CWI inspectors Mr. Chung Kuan. Based on Caltrans QA observation, the FCAW welding operation appeared to be in general compliance with requirements of AWS D1.5 2002 and Caltrans contract documents.

Summary of Conversations:

The CWI Mr. Chung Kuan reported that FCAW welding on two ribs will be stopped when the weld is 70% complete, the tower sddle will turn 180 degree for other side welding.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510)385-5910, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Inspected By: Pau,Wai Quality Assurance Inspector **Reviewed By:** Lanz,Joe QA Reviewer